

Date: Wednesday, 6/6/2007 2:01:52 PM
 User: Kim Johnston

Process Sheet

4/0 507/08/27 26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY
 Job Number : 32814
 Estimate Number : 11005
 P.O. Number : N/A Part Number : D412704041
 This Issue : 6/6/2007 S.O. No. : N/A Drawing Number : D412-704-041 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 29896 Material : N/A
 Due Date : 6/26/2007 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added
 Figures 1-3 KJ/RF
 Est Rev:C 06.03.08 Re-format EC
 Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20
 JLM
 Est Rev:E 07.05.02 Reformat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3204041 Pedal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3204-041 Pedal Assembly B 30829 x 5

✓
 mel

2.0 D32051 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3205-1 Bracket B 30830 x 4
 B 28941 x 2 (-1)

✓
 mel

3.0 D32053 Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3205-3 GHW Bracket 32823 x 5
 B 28942 x 1

✓
 mel

4.0 D32061 Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3206-1 Pedal Arm B 29915 x 6 (-1)

✓
 mel 07/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/03/27	13	Split W/O	SB	07/03/27	5		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3206-1 Pedal arm

5.0 D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3209-.041	Bracket

batch

B 23194 X 2

B 30832 X 4

(-1)

✓

ml

6.0 AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN3-10A	Bolt

batch

M17566

(-1)

✓

ml

7.0 AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN315-4R	Nut

batch

M17566

(-1)

✓

ml

8.0 AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN4-10A	Bolt

batch

M101291

(-1)

✓

ml

9.0 AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description
2	AN4-12A	Bolt

batch

M104547

(-2)

✓

ml 07/07/20

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description batch

1 AN4-13A Bolt

M104746

(-1)

✓

ml

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part number Description batch

5 AN960JD10 Washer

M104885

(-5)

✓

ml

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 66.0000 Each(s)

Pick:

Qty Part number Description batch

11 AN960JD416 Washer

M104215

(-11)

✓

ml

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part number Description batch

3 AN960JD416L Washer

M104214

(3)

✓

ml

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description batch

1 MS21042L3 Nut

M103830

(-1)

✓

ml

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part number Description batch

5 MS21042L4 Nut

M102552

(-5)

✓

ml 07/07/00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

(-1)

✓

ml

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

(-1)

ml 07/07/20

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

P10

X5

ml 07/08/28

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/06/06 (+4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M103044

✓

ml 07/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: JD Date: 8/18/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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07/09/04	#180	one part PEDAL assembly Pedal Assemblyment (D3204-041) Bunch with D3205-1 found during inspection R.C. D3204-041 looks like it was squashed when Bunching was pressed in.	<i>[Signature]</i> 05/04/11	seron D3204-041 Remove ALL HARDWARE and Relable with Batch and Part #'s.	SAD 07/09/06 GAD 07/09/06 <i>[Signature]</i>	Er 7/6/06	<i>[Signature]</i> 05/04/11	En 07/09/04

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Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part number

Description

batch

2

AN3-6A

Bolt

M100184

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Batch:

M104936

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

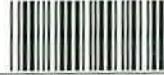


Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11/07/09.11

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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